



Dart Aerospace Ltd.
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D3210-1

Job Sheet 190751



Part No: D3210-1

Job Qty: 10 pcs

DAS
21
9-89

Part Name: Doubler For Interior Window -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now On Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		3/22/19	0.00	2.40	Waterjet - Flow	9/15/19	JRB
120	QC 8	10		3/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
130	Small Fab - 2 - B4B	10 pcs		3/22/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
140	QC 5	10 pcs		3/22/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		

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Container No: S218255

Part: D3210-1

Job No: 190751

Serial No/Batch: S218255

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/30/19

DAS
40
9-89

SEP 3 0 2019

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					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	Handfinish - 1-1 Chemical-B4B	10 pcs	3/22/19	0.00 0.69	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	OCT 01 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
155	QC 7	10 pcs	3/22/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	

				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BL 19-10-2
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
160 Powdercoat - 4 Black Sand - B4B	10 pcs	3/22/19	0.00 0.32	Powdercoat - 1 - B4B	
M138910.				Powdercoat - 2 - B4B	
START: 10:05 O.V.T. 30° FINISH: 10:35.				Powdercoat - 3 - B4B	BL 19-10-8
170 QC 3	10 pcs	3/22/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	OCT 02 2019
				QC 3 - 68	
				QC 3 - 9	
180 Packaging 3-1 - Stock - B4B	10 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	ST438
				Packaging 3 - 5 - B4B	DAS 74
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	10 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - 1-Cut as per Dwg D3210 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Small Fab) Deburr 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 155 - (QC7-Inspect Chemical Conversion Coat) 160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.080	2024-T3 .080 Sheet	17 sf (1.7 ea)	100-Waterjet - Flow - 1	5216343	

OCT 0 2 2019

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.080	17	74	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.141inches	+ 0.005 - 0.000	0.146 0.141	
2	Doubler	0.128Inches	+ 0.005 - 0.000	0.133 0.128	
3	Doubler	3.857inches	± 0.010	3.867 3.847	
4	Doubler	17.750inches	± 0.010	17.760 17.740	
5	Doubler	20.150inches	± 0.030	20.180 20.120	
6	Doubler	8.500inches	± 0.010	8.510 8.490	
7	Doubler	1.095inches	± 0.010	1.105 1.085	
8	Doubler	0.650inches	± 0.010	0.660 0.640	
9	Doubler	0.350inches	± 0.010	0.360 0.340	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐
Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	

Other/Details: _____